



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.4110

Job Sheet 198481



Part No: 647.4110

Job Qty: 12 pcs

DAS
21
9-89

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C3 SHEET 1 IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
110	Waterjet - Flow - 1	12 pcs	8/30/19	8/30/19	0.02	0.74	Waterjet - Flow 8/27/19	JRB
120	QC 2	12 pcs	8/30/19	8/30/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

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7/30/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

130	QC 8	12 pcs	8/30/19	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	8/27/19 JRB
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	AUG 27 2019 DAS 40 9-89
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140	Small Fab - 2 - B4B	12 pcs	8/30/19	0.00 0.80	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	DAS 30 9-89
					Small Fab - 4 - B4B	SEP 13 2019
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
150	QC 5	12 pcs	8/30/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS 40 9-89
					QC 5 - 61	SEP 13 2019
					QC 5 - 81	
160	Outsource - 4 - Anodize	12 pcs	8/30/19		ATG001-VC	
170	Packaging 2-1 - Receive - B4B	12 pcs	8/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	

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					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21 ✓	cck 080	
				QC 21 - SA - 70	DAS	
				QC 21 - SA - 53	21	

Part Op 110 - 1-Cut as per Dwg

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - FORM AS PER DWG

150 - (QC5- Inspect part completeness to step on W/O)

160 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 647.4100

170 - (Receive & Inspect for Damage & Mat'l Certs)

180 - (QC5- Inspect part completeness to step on W/O)

210 - (QC21- Final Inspection - Work Order Release) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

220 - (QC21- Final Inspection - Work Order Release)

DAS
21
9-89

OCT 08 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	14.7240 sf (1.227 ea)	110-Waterjet - Flow - 1	5180490

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.063	15	105	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.625inches $\pm$ 0.010	0.635 0.615		
2	Doubler	5.841inches $\pm$ 0.010	5.851 5.831		
3	Doubler	4.080inches $\pm$ 0.010	4.090 4.070		
4	Doubler	0.738inches $\pm$ 0.010	0.748 0.728		
5	Doubler	1.625inches $\pm$ 0.010	1.635 1.615		
6	Doubler	12.625inches $\pm$ 0.010	12.635 12.615		
7	Doubler	12.125inches $\pm$ 0.010	12.135 12.115		
8	Doubler	3.772inches $\pm$ 0.010	3.782 3.762		
9	Doubler	1.125inches $\pm$ 0.010	1.135 1.115		
10	Doubler	0.500inches $\pm$ 0.010	0.510 0.490		
11	Doubler	1.000inches $\pm$ 0.010	1.010 0.990		
12	Doubler	2.551inches $\pm$ 0.010	2.561 2.541		
13	Doubler	7.000inches $\pm$ 0.010	7.010 6.990		
14	Doubler	11.449inches $\pm$ 0.010	11.459 11.439		
15	Doubler	13.000inches $\pm$ 0.010	13.010 12.990		
16	Doubler	13.500inches $\pm$ 0.010	13.510 13.490		
17	Doubler	14.000inches $\pm$ 0.010	14.010 13.990		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐
Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐
Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐
Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐	

Other/Details: _____



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044527**



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044527

PO Date: 9/17/19

Due Date: 9/25/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-23

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192698	649.4817	Shim : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	9/25/19	32 pcs	0 pcs	32 pcs	\$7.00/pcs	\$224.00
2	198471	646.3716	Gauge Bracket : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed	-	9/25/19	22 pcs	0 pcs	22 pcs	\$6.90/pcs	\$151.80



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PURCHASE ORDER

POHB044527



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	197035	649.4818	Shim : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed -		9/25/19	10 pcs 9 pcs	0 pcs	10 pcs	\$7.30/pcs	\$73.00
4	197034	649.4814	Doublers : Various STC's ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2) PRIME IAW MIL-P- 23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)	Firmed -		9/25/19	22 pcs	0 pcs	22 pcs	\$7.00/pcs	\$154.00
5	199202	RBWA353A04-06	Cap (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed -		9/25/19	10 pcs	0 pcs	10 pcs	\$13.25/pcs	\$132.50



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	197053	649.5211	Shim : Various STC's Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N	Firmed -		9/25/19	15 pcs	0 pcs	15 pcs	\$7.50/pcs	\$112.50
7	197036	649.4819	Shim : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1), Issue P/O: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed -		9/25/19	42 pcs	0 pcs	42 pcs	\$7.50/pcs	\$315.00
8	198481	647.4110	Doubler : Various STC's Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 647.4100	Firmed -		9/25/19	13 pcs	0 pcs	13 pcs	\$24.00/pcs	\$312.00
Grand Total:										\$1,474.80	



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PURCHASE ORDER

POHB044527



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/23/19 1:32 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918655

Date: 25-Sep-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
32 ea	Part: 649.4817 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5 mils) Prime per MIL-PRF-2337, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing Batch/Lot#: 9731-F-J19 Expiry Date: 06/20 Job: 25910 Line: 1 PO: POHB044527		Rev: E
22 ea	Part: 649.4814 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5 mils) Prime per MIL-PRF-2337, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 9731-F-J19 Expiry Date: 06/20 Job: 25988 Line: 4 PO: POHB044527		Rev: E
15 ea	Part: 649.5211 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5 mils) Prime per MIL-PRF-2337, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 9731-F-J19 Expiry Date: 06/20 Job: 25990 Line: 6 PO: POHB044527		Rev: C
Made in Canada.			

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SEP 25 2019
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SEP 25 2019
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918655

Date: 25-Sep-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery
Quantity	Description
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>SEP 25 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918653

Date: 25-Sep-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
9 ea	Part: 649.4818 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 25973 PO: POHB044527	Rev: E	Expiry Date: 06/20 Line: 3
42 ea	Part: 649.4819 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 25991 PO: POHB044527	Rev: E	Expiry Date: 06/20 Line: 7
13 ea	Part: 647.4110 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 25992 PO: POHB044527	Rev: N/C	Expiry Date: 06/20 Line: 8

Made in Canada.

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SEP 25 2019

DART AEROSPACE LTD.

DAS
61
9-89



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918653

Date: 25-Sep-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Quantity	Description
	Terms
	Ship Via
	ATG Delivery
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.
	Date: <u>SEP 25 2019</u>
	Certified Signature: <u></u>
	Receiver Signature: _____
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.
	Made in Canada.